

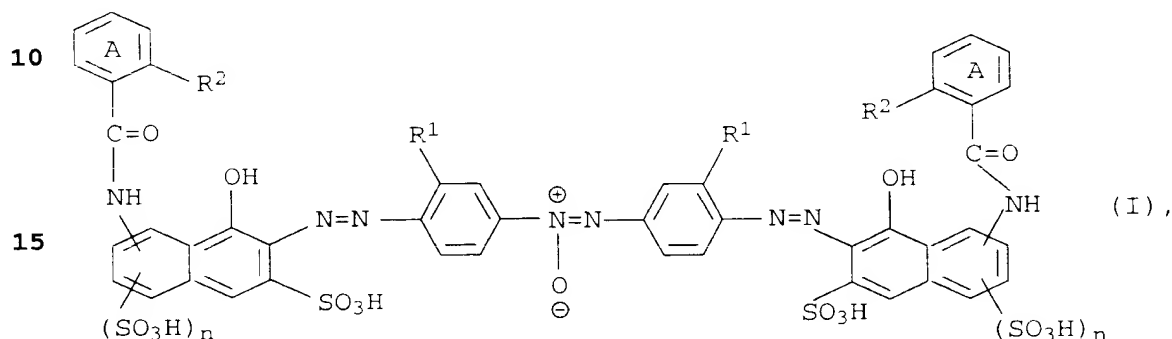
13 SEP 2001

## Azoxy dyes and copper complexes thereof

## Specification

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The present invention relates to novel azoxy dyes of the general formula I in the form of the free acid



20 where

$n$  is 0 or 1, each

25  $R^1$  is selected from the group consisting of methoxy, hydroxyl and carboxyl, each

30  $R^2$  is selected from the group consisting of carboxyl, amino,  $C_1$ - $C_4$ -alkylamino, allylamino, benzylamino and methoxycarbonylmethylamino, and the phenyl rings A may additionally be substituted by  $C_1$ - $C_8$ -alkyl, unsubstituted or methyl- or halogen-substituted phenyl, hydroxyl, amino, nitro, halogen, carboxyl, N-benzylcarbamoyl, unsubstituted or nitro-, halogen-,  $C_1$ - $C_4$ -alkoxy- or acetoxysubstituted phenylcarbamoyl and naphthylcarbamoyl

35 or be benzofused,

their copper complexes, a process for preparing the copper complex dyes, azoxy dyes of the formula I in their partially or completely deacylated form, their copper complexes, colorants

40 comprising these azoxy dyes and/or their copper complexes and their use for dyeing and printing natural or synthetic substrates.

CH-A-193 343, CH-A-196 252, CH-A-196 259, CH-A-196 260, CH-A-196

45 264, DE-A-26 51 369, EP-A-648 814 and EP-A-43 792 describe azoxy dyes containing various hydroxyaminonaphthalenesulfonic acids and their copper complexes.

DE-A-28 44 597 teaches a process for preparing copper-containing azoxy dyes whose coupling component is a 4-hydroxy-6-sulfophenylaminonaphthalene-2-sulfonic acid.

- 5 The prior art dyes are dull and frequently provide unlevel dyeings.

It is an object of the present invention to provide dyes which do not have the abovementioned disadvantages and which possess good  
10 application properties.

We have found that this object is achieved by the above-described dyes and their copper complexes.

- 15 Any alkyl appearing in the abovementioned formula may be straight-chain or branched.

Additionally substituted phenyl rings A may each bear 1, 2, 3 or 4, preferably 1 or 2, substituents, which may be different.

20

Halogen is fluorine, chlorine, bromine or iodine.

R<sup>2</sup> is for example methylamino, ethylamino, propylamino, isopropylamino, butylamino, isobutylamino, sec-butylamino and

- 25 tert-butylamino.

Substituents for the phenyl rings A include for example methyl, ethyl, propyl, isopropyl, butyl, sec-butyl, tert-butyl, pentyl, hexyl, heptyl, octyl, 2-, 3- or 4-bromophenyl, 2-, 3- or  
30 4-methylphenyl, 2-, 3- or 4-nitrophenylcarbamoyl, 2-, 3- or 4-methoxyphenylcarbamoyl, 2-methoxy-4-nitro- and 2-methoxy-5-nitrophenylcarbamoyl, 2-, 3- or 4-ethoxyphenylcarbamoyl and 2-, 3- or 4-acetoxyphenylcarbamoyl.

- 35 In the description part and in the claims, the dyes of the formulae I, VI, VII, VIII and IX are depicted in the form of the free acids, but preferably they are present as salts, especially as alkali metal salts, and are isolated as salts from the synthesis. The formula depiction as free acid must therefore, as  
40 customary in the dye literature, be considered equivalent to the depiction as salt.

Suitable cations are derived from metal or ammonium ions. Metal ions are in particular the lithium, sodium or potassium ions.

- 45 Ammonium ions for the purposes of the present invention are unsubstituted or substituted ammonium cations. Substituted ammonium cations include for example monoalkyl-, dialkyl-,

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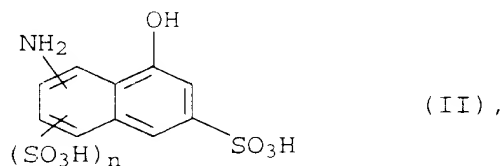
trialkyl-, tetraalkyl- or benzyltrialkyl-ammonium cations for example diethanolammonium or cations derived from nitrogenous five- or six-membered saturated heterocycles, such as pyrrolidinium, piperidinium, morpholinium, piperazinium or

- 5 N-alkylpiperazinium cations or their N-monoalkyl- or N,N-dialkyl-substituted products. Alkyl is here to be understood as meaning in general straight-chain or branched  $C_1$ - $C_{20}$ -alkyl, which may be substituted by 1 or 2 hydroxyl groups and/or interrupted by from 1 to 4 oxygen atoms in ether function.

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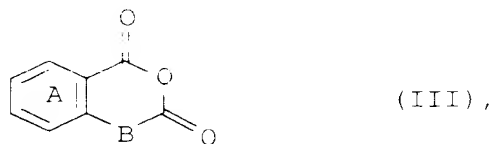
The dyes may be prepared by reacting an aminohydroxynaphthalenesulfonic acid of the formula II

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- 20 where n is 0 or 1, with an anhydride of the formula III

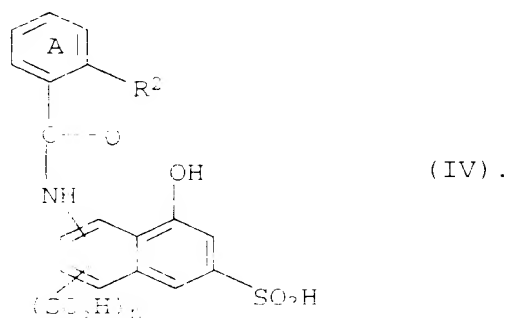
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where B is a single bond or imino,  $C_1$ - $C_4$ -alkylimino or phenylimino and A is as defined above, in a weakly alkaline medium to form a coupling component of the formula IV

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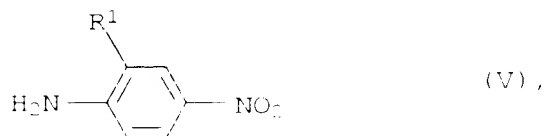
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This coupling component may be coupled with nitroanilines of the formula V

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where  $R^1$  is as defined above, as diazo component in a conventional manner before two resultant nitromonoazo dyes are reductively linked via an azoxy bridge to form the dyes of the invention.

- 5 The reducing agents used are preferably reducing sugars, for example D-glucose, in aqueous alkaline solution. The solution may be rendered alkaline for example by means of an alkali metal hydroxide such as sodium hydroxide or lithium hydroxide. Such reductions are common knowledge and described for example in
- 10 EP-A-43 792. In addition, a reduction with customary reducing agents such as aldehydes e.g. formaldehyde or hydrazine hydrate is possible.

Suitable aminohydroxynaphthalenesulfonic acids II include for

15 example 1-amino-8-hydroxynaphthalene-4,6-disulfonic acid, 2-amino-8-hydroxynaphthalene-6-sulfonic acid, 3-amino-8-hydroxynaphthalene-6-sulfonic acid, 4-amino-8-hydroxynaphthalene-6-sulfonic acid and particularly preferably 1-amino-8-hydroxynaphthalene-3,6-disulfonic acid.

20 Examples of anhydrides III are

- phthalic anhydrides such as phthalic anhydride, 3-methyl-, 4-methyl-, 3,6-dimethyl-, 4-tert-butyl-, 3,4,5,6-tetramethyl-,
- 25 3-o-tolyl-, 3,6-diphenyl-, 3-hydroxy-, 4-carboxy-, 3-amino-, 3-nitro-, 4-nitro-4-(2,4-dichlorophenyl)carbamoyl-, 4-(3,4-dichlorophenyl)carbamoyl-, 4-(2-methoxy-5-chlorophenyl)carbamoyl-, 4-(3-nitrophenyl)carbamoyl-,
- 30 4-(2-methoxy-4-nitrophenyl)carbamoyl-, 4-(2-methoxy-5-nitrophenyl)carbamoyl-, 4-(4-acetamidophenyl)carbamoyl-, 4-(2-ethoxyphenyl)carbamoyl-, 4-naphthylcarbamoyl-, 4-benzylcarbamoyl-, 3-fluoro-, 4-fluoro-, 3,4,5,6-tetrafluoro-, 3,6-difluoro-, 3,4-difluoro-, 3-chloro-,
- 35 4-chloro-, 3,6-dichloro-, 4,5-dichloro-, 3,4,5,6-tetrachloro-, 4-bromo-, 3,4,5,6-tetrabromo-, 3,4,5,6-tetraiodo- and 3-(4-bromo)phenyl-phthalic anhydride.

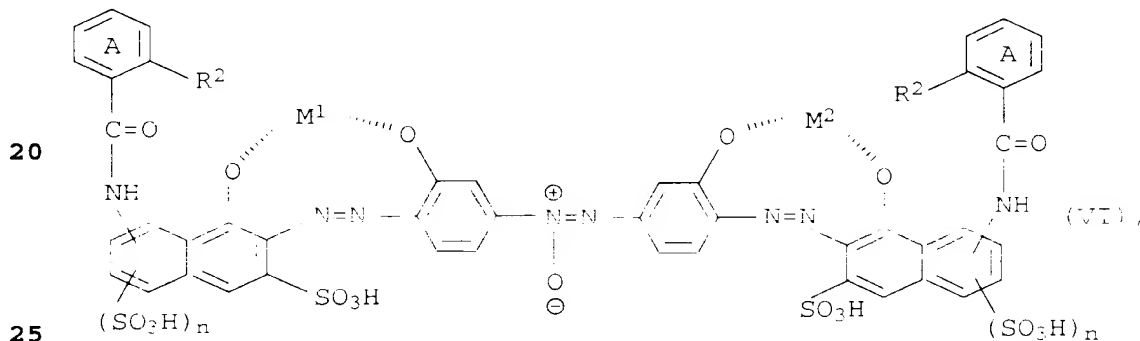
isatoic anhydrides such as isatoic anhydride, 6-methyl-,

40 6-hydroxy-, 5-hydroxy-, 4-carboxy-, 4-nitro-, 5-nitro-, 5-amino-, 6-fluoro-, 5-chloro-, 6-chloro-, 3,5-dichloro-, 5-bromo-, N-methyl-, N-ethyl-, N-benzyl-, N-allyl-, N-methyl-5-nitro-, N-methyl-5-chloro-, N-methyl-6-chloro- and N-methoxycarbamoylmethyl-isatoic anhydride, and also

-naphthalene-1,2-dicarboxylic and naphthalene-2,3-dicarboxylic anhydrides.

The present invention further provides copper complex dyes and their mixtures which are obtainable by reacting dyes I with at least 0.1 mol equivalent of a copper donor. Preferably, 0.1 - 2 mol of a copper donor is used per mole of dye. Amounts above 2 mol equivalents are possible, but have no influence on the product. Incomplete formation of 2:1 complexes, i.e., the use of < 2 mol equivalents of the copper donors, provides mixtures of the uncomplexed, singly copper-complexed and doubly copper-complexed dyes.

The copper complex dyes conform to the general formula VI in the  
15 form of the free acid



where at least one of  $M^1$  and  $M^2$  is copper(II) and any which is not is hydrogen and methyl, and n,  $R^2$  and A are each as defined above. When  $M^1$  or  $M^2$  is hydrogen and methyl, the methyl radical will form the methoxy group on the phenyl ring and the hydrogen will form the hydroxyl group on the naphthalene structure.

Copper complex dyes obtained by reaction with 0.5 - 1.7 mol, especially 0.5 - 1.5 mol, of copper donor per mole of dye are preferred.

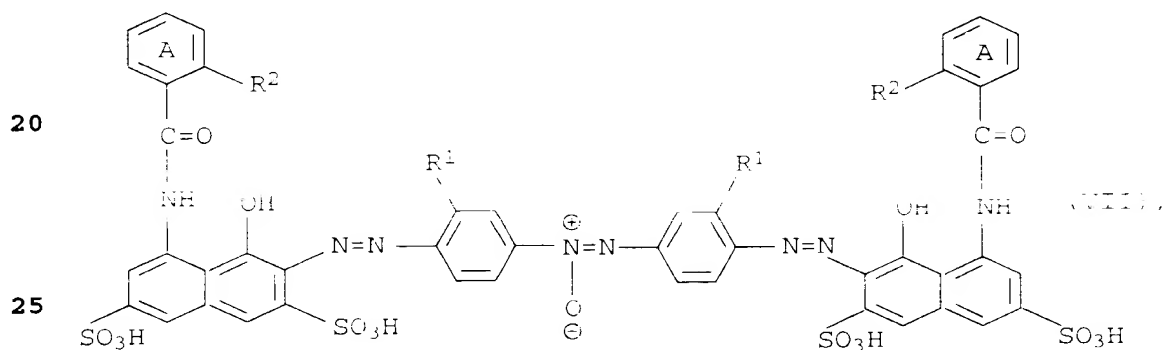
The copper donors used may be salts which contain the copper as cation, for example copper sulfate, copper chloride or copper acetate. In some cases, the use of complex copper compounds is of  
40 advantage, for example in the form of copper-ammine complexes, such as coppertetrammine sulfates from copper sulfate and ammonia, pyridine or monoethanolamine, or in the form of compounds which contain the copper in complexed form, for example complex copper compounds of the alkali metal salts of aliphatic  
45 aminocarboxylic acids or hydroxycarboxylic acids, as of

glycocoll, of lactic acid and in particular of tartaric acid, such as sodium copper tartrate.

The treatment with the copper donor takes place in an aqueous or  
 5 organic/aqueous medium, for example at room temperature, if readily metallizable starting compounds are present, or by heating to 50 - 120°C in an open vessel, for example under reflux, or if necessary in a closed vessel under superatmospheric pressure, the pH conditions being determined by the nature of the  
 10 metallization method chosen.

If desired, solvents, for example alcohol, dimethylformamide, etc., can also be added during the metallization.

15 Preference is given to dyes of the general formula VII in the form of the free acid



where R<sup>1</sup>, R<sup>2</sup> and A are each as defined above, and their copper complexes.

30 Preference is further given to dyes I where each R<sup>1</sup> is methoxy and to the copper complexes obtainable therefrom.

35 Preference is also given to dyes I and their copper complexes where the phenyl rings A are unsubstituted, i.e., bear the R<sup>2</sup> only, or C<sub>1</sub>-C<sub>4</sub>-alkyl-substituted.

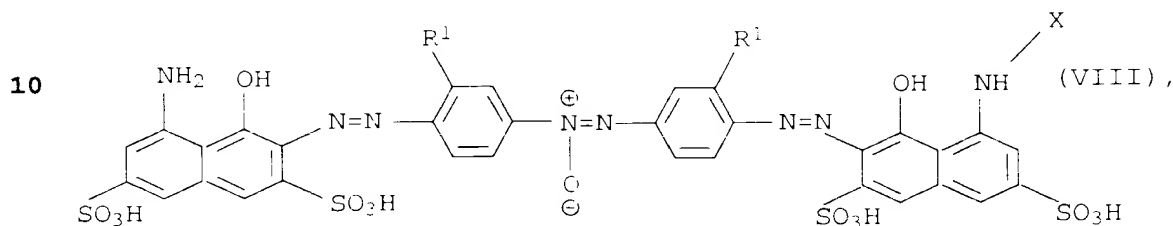
Preference is given to the dyes I and VII and their copper complexes where each R<sup>2</sup> is carboxyl

40 Preference is given in particular to dyes I and VII where R<sup>1</sup> is methoxy, R<sup>2</sup> is carboxyl and the phenyl rings A bear C<sub>1</sub>-C<sub>4</sub>-alkyl as further substituents or preferably are unsubstituted. The copper complexes obtainable therefrom are preferred in particular.

45

Preference is given in particular to the copper complex mixture of the preferred dyes which are obtained by reaction with 0.1-2, especially 0.5-1.7, mol equivalents of a copper donor.

- 5 The present invention further provides azoxy dyes of the general formula VIII in the form of the free acid

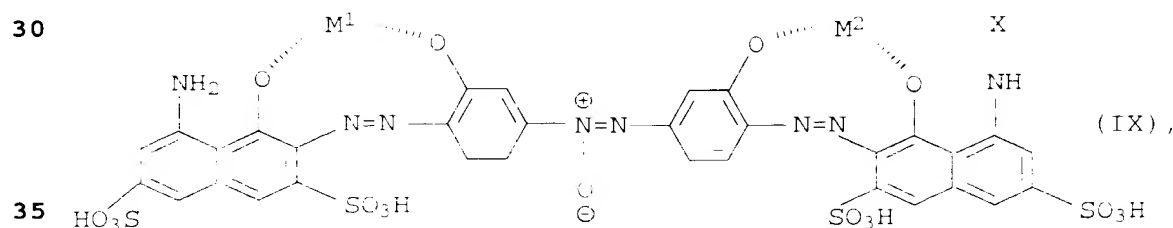


- 15 where X is hydrogen or a radical of the formula



and  $R^1$ ,  $R^2$  and A are each as defined above.

- 25 The present invention further provides copper complex dyes of the general formula IX in the form of the free acid



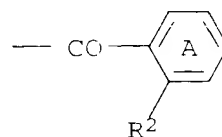
where  $M_1$ ,  $M_2$  and X are each as defined above.

- 40 Preference is given to azoxy dyes of formula VIII in the form of the free acid where X is hydrogen.

Preference is further given to copper complex dyes of formula IX in the form of the free acid where X is hydrogen.

The azoxy dyes of the formula VIII are obtained as described above for the azoxy dyes of the formula I. The partial or complete detachment of the radical

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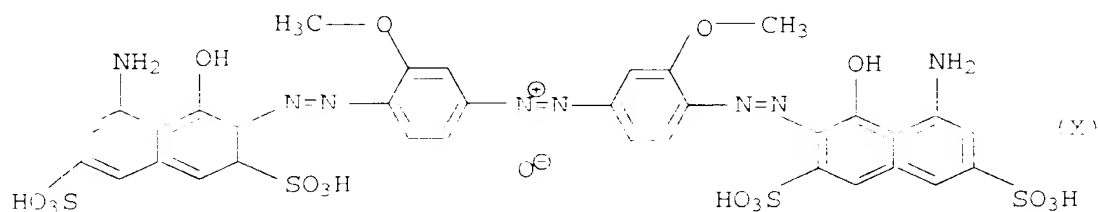


- 10 (deacylation) can be effected by controlling the pH after the reduction of the nitromonoazo dyes to the azoxy compound. Working in aqueous solution at a pH below 9 practically provides for complete deacylation to the azoxy dyes of the formula VIII (X = hydrogen).

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The dye of the formula X

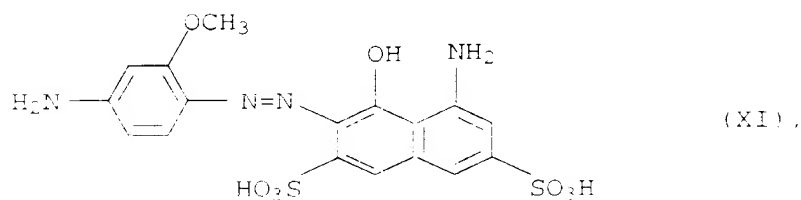
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is formally known from EP-A-648 814, where it is described in Example 3. However, it has been determined that, when this example is repeated, the monoazo dye of the formula XI

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is obtained instead of the abovementioned dye X.

- 40 The metal complex dyes of the invention can be used alone, in mixtures with each or one another and with the azoxy dyes I and VIII and together with other cationic or anionic compounds in the form of their solutions or in the form of powders or granules.
- 45 Dye preparations comprising the novel dyes of the formula I, VII, VIII and/or IX preferably further comprise polymers, such as polyvinylamines, polyvinylamides, polyvinyl acetates, polyvinyl



alcohols, polyvinylpyrrolidones or copolymers of the respective monomers. Similarly, oligomers of ethyleneimine, ethylene oxide or propylene oxide or derivatives thereof may be used. Further preferred additives are glycols such as 1,2-glycol,  
5 1,2-propanediol, 2,3-butylene glycol, diethylene glycol, triethylene glycol, ethyltetraglycol, dipropylene glycol, ethylene glycol monopropyl ether, methyldiglycol, triethylene glycol monobutyl ether, triethylene glycol monopropyl ether, diethylene glycol monoethyl ether, diethylene glycol dibutyl  
10 ether and particularly preferably urea.

They are very useful for dyeing or printing polymeric material, especially papery materials such as paper and paperboard, but also cellulose, cotton, leather, bast fibers, hemp, flax, sisal,  
15 jute, coir, straw or anionically modified fibers and also in recording fluids such as inks especially for ink-jet or printing inks.

The dyes of the invention are particularly useful in the  
20 production of pulp-dyed, sized and unsized paper. They are likewise useful for dyeing paper by the pulp method.

Paper, leather and cellulose are dyed in a conventional manner.

25 The copper complex dyes of the invention provide different bright blues. They have very good affinity for paper. The novel dyes and their preparations color the papermaking wastewater only minimally, if at all, which is particularly favorable from the aspect of keeping the water courses clean. They are substantive,  
30 do not marble on paper and are substantially pH-insensitive. Dyeings on paper are notable for good lightfastness. On prolonged exposure to light the hue changes on-tone.

The dyed papers, which exhibit good bleachability, are wetfast,  
35 not only with regard to water, but also with regard to milk, soapy water, sodium chloride solutions, fruit juices or sweetened mineral water, and are also stable to alcoholic drinks because of their good alcoholfastness.

40 The novel dyes can also be used for dyeing, padding or printing polyacrylonitrile textiles or anionically modified polyamide or polyester textiles.

The Examples which follow illustrate the invention.

45 Preparation of coupling components

## Example 1

34.1 g of the monosodium salt of  
1-amino-8-hydroxynaphthalene-3,6-disulfonic acid were introduced  
5 into 250 g of water. A pH of 7-8 was set with 10% strength by  
weight sodium hydroxide solution. 19.3 g of phthalic anhydride  
were then added at 20-25°C, and 10% strength by weight sodium  
hydroxide solution was used to maintain the pH within the range  
from 7 to 8 during the subsequent stirring time of 3 h as well.  
10 The completeness of the conversion of the  
1-amino-8-hydroxynaphthalene-3,6-disulfonic acid was verified by  
means of thin layer chromatography. The coupling component  
solution thus prepared was used for dye synthesis without  
intermediate isolation.

15

## Example 2

34.1 g of the monosodium salt of  
1-amino-8-hydroxynaphthalene-3,6-disulfonic acid were introduced  
20 into 300 g of water. A pH of 6-8 was set with 10% strength by  
weight sodium carbonate solution. 18 g of isatoic anhydride were  
then added at 20-30°C, and 10% strength by weight sodium carbonate  
solution was used to maintain the pH within the range from 6 to 8  
during the subsequent stirring time overnight as well. The  
25 completeness of the conversion of the  
1-amino-8-hydroxynaphthalene-3,6-disulfonic acid was verified by  
means of thin layer chromatography. The coupling component  
solution thus prepared was used for dye synthesis without  
intermediate isolation.

30

## Example 3

34.1 g of the monosodium salt of  
1-amino-8-hydroxynaphthalene-3,6-disulfonic acid were introduced  
35 into 200 g of water. A pH of 7-9 was set with 25% strength by  
weight potassium hydroxide solution. 26.5 g of  
4-tert-butylphthalic anhydride were then added at 20-25°C, and 25%  
strength by weight potassium hydroxide solution was used to  
maintain the pH within the range from 7 to 9 during the  
40 subsequent stirring time of 4 h as well. The completeness of the  
conversion of the 1-amino-8-hydroxynaphthalene-3,6-disulfonic  
acid was verified by means of thin layer chromatography. The  
coupling component solution thus prepared was used for dye  
synthesis without intermediate isolation.

45

## Example 4

34.1 g of the monosodium salt of 1-amino-8-hydroxynaphthalene-3,6-disulfonic acid were introduced into 250 g of water. A pH of 7-8 was set with 10% strength by weight sodium hydroxide solution. 30.9 g of N-methoxycarbonylmethylisatoic anhydride were then added at 20-25°C, and 10% strength by weight sodium hydroxide solution was used to maintain the pH within the range from 7 to 8 during the subsequent stirring time of 3 h as well. The completeness of the conversion of the 1-amino-8-hydroxynaphthalene-3,6-disulfonic acid was verified by means of thin layer chromatography. The coupling component solution thus prepared was used for dye synthesis without intermediate isolation.

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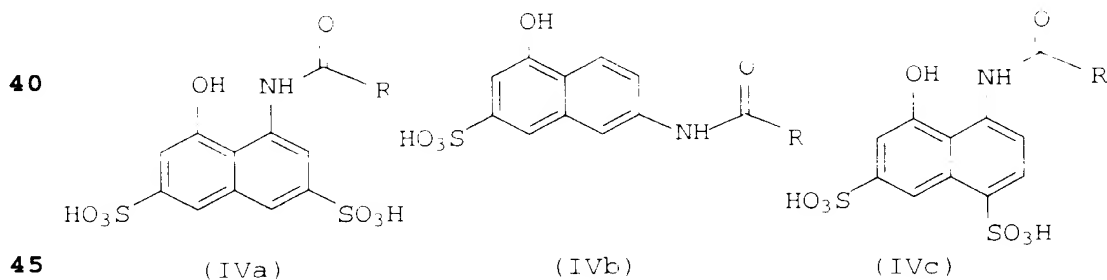
## Example 5

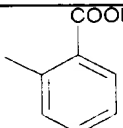
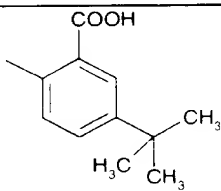
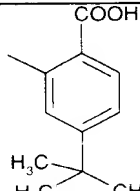
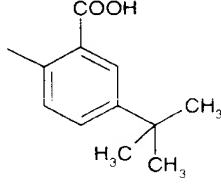
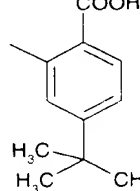
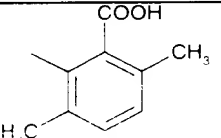
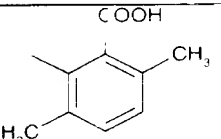
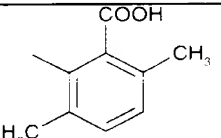
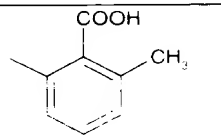
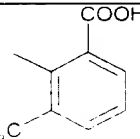
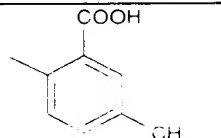
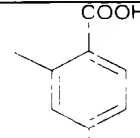
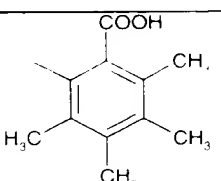
23.9 g of 3-amino-8-hydroxynaphthalene-6-sulfonic acid were introduced into 300 g of water. A pH of 7-8 was set with 10% strength by weight sodium hydroxide solution. 20.8 g of phthalic anhydride were then added at 20-25°C, and 10% strength by weight sodium hydroxide solution was used to maintain the pH within the range from 7 to 8 during the subsequent stirring time overnight as well. The completeness of the conversion of the 3-amino-8-hydroxynaphthalene-6-sulfonic acid was verified by means of thin layer chromatography. The coupling component solution thus prepared was used for dye synthesis without intermediate isolation.

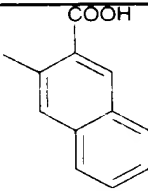
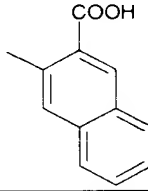
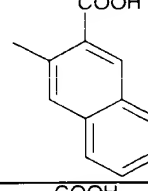
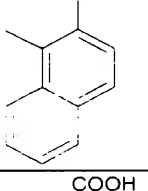
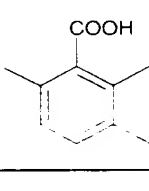
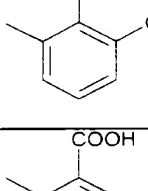
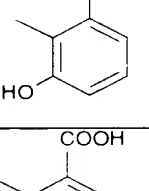
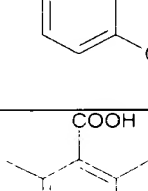
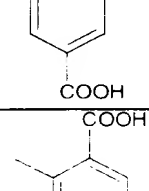
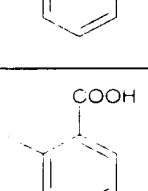
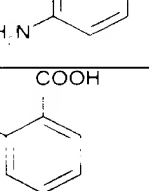
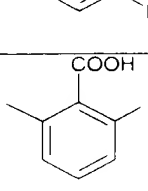
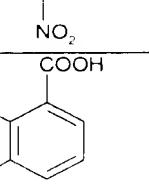


Examples 1-5 are repeated with 1-amino-8-hydroxynaphthalene-3,6-disulfonic acid, 3-amino-8-hydroxynaphthalene-6-sulfonic acid and 1-amino-8-hydroxynaphthalene-4,6-disulfonic acid to prepare the coupling components of the general formulae Va, Vb and Vc

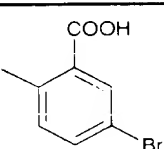
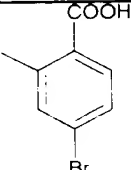
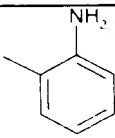
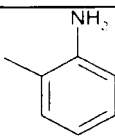
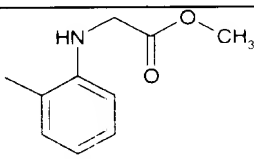
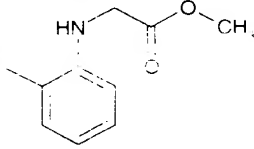
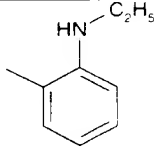
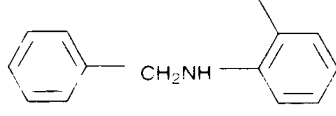
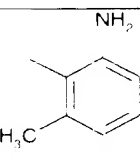
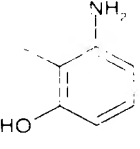
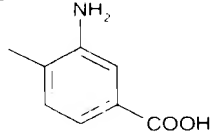
35 mentioned in Table 1.

Table 1:



Ex-ample	Naphthalene acid used	Anhydride used	—R
5	6 1-amino-8-hydroxy-naphthalene-4,6-disulfonic acid	phthalic anhydride	
10	7 3-amino-8-hydroxy-naphthalene-6-sulfonic acid	4-tertiary-butylphthalic anhydride	 + 
15	8 1-amino-8-hydroxy-naphthalene-4,6-disulfonic acid	4-tertiary-butylphthalic anhydride	 + 
20	9 1-amino-8-hydroxy-naphthalene-3,6-disulfonic acid	3,6-dimethylphthalic anhydride	
25	10 3-amino-8-hydroxy-naphthalene-6-sulfonic acid	3,6-dimethylphthalic anhydride	
30	11 1-amino-8-hydroxy-naphthalene-4,6-disulfonic acid	3,6-dimethylphthalic anhydride	
35	12 1-amino-8-hydroxy-naphthalene-3,6-disulfonic acid	3-methylphthalic anhydride	 + 
40	13 1-amino-8-hydroxy-naphthalene-3,6-disulfonic acid	4-methylphthalic anhydride	 + 
45	14 1-amino-8-hydroxy-naphthalene-3,6-disulfonic acid	3,4,5,6-tetramethylphthalic anhydride	

	Ex-ample	Naphthalene acid used	Anhydride used	—R
5	15	1-amino-8-hydroxy-naphthalene-3,6-disulfonic acid	naphthalene-2,3-dicarboxylic anhydride	
10	16	3-amino-8-hydroxy-naphthalene-6-sulfonic acid	naphthalene-2,3-dicarboxylic anhydride	
15	17	1-amino-8-hydroxy-naphthalene-4,6-disulfonic acid	naphthalene-2,3-dicarboxylic anhydride	
20	18	1-amino-8-hydroxy-naphthalene-3,6-disulfonic acid	naphthalene-1,2-dicarboxylic anhydride	 + 
25	19	1-amino-8-hydroxy-naphthalene-3,6-disulfonic acid	3-hydroxy-phthalic anhydride	 + 
30	20	1-amino-8-hydroxy-naphthalene-3,6-disulfonic acid	4-carboxy-phthalic anhydride	 + 
35	21	1-amino-8-hydroxy-naphthalene-3,6-disulfonic acid	3-aminophthalic anhydride	 + 
40	22	1-amino-8-hydroxy-naphthalene-3,6-disulfonic acid	4-nitrophthalic anhydride	 + 
45	23	1-amino-8-hydroxy-naphthalene-3,6-disulfonic acid	3-chlorophthalic anhydride	 + 

Ex-ample	Naphthalene acid used	Anhydride used	— R
5 24	1-amino-8-hydroxy-naphthalene-3,6-disulfonic acid	4-bromophthalic anhydride	 + 
10 25	3-amino-8-hydroxy-naphthalene-6-sulfonic acid	isatoic anhydride	
15 26	1-amino-8-hydroxy-naphthalene-4,6-disulfonic acid	isatoic anhydride	
20 27	3-amino-8-hydroxy-naphthalene-6-sulfonic acid	N-(methoxycarbonylmethyl)-isatoic anhydride	
25 28	1-amino-8-hydroxy-naphthalene-4,6-disulfonic acid	N-(methoxycarbonylmethyl)-isatoic anhydride	
30 29	1-amino-8-hydroxy-naphthalene-3,6-disulfonic acid	N-ethylisatoic anhydride	
35 30	1-amino-8-hydroxy-naphthalene-3,6-disulfonic acid	N-benzylisatoic anhydride	
40 31	1-amino-8-hydroxy-naphthalene-3,6-disulfonic acid	6-methylisatoic anhydride	
45 32	1-amino-8-hydroxy-naphthalene-3,6-disulfonic acid	6-hydroxyisatoic anhydride	
	33	4-carboxyisatoic anhydride	

Preparation of azoxy dyes according to the invention

Example 34

- 5 16.8 g of 2-methoxy-4-nitroaniline were precharged in 200 g of water and mixed with 30 g of concentrated hydrochloric acid. 32 ml of 23% strength by weight sodium nitrite solution were then added at 0-10°C over 30 minutes. After 2 h excess nitrite was destroyed with amidosulfonic acid and the diazo component thus
- 10 prepared was added at 15-20°C over 20 minutes to the coupling component prepared in Example 1. The pH was maintained at 8-9 by the simultaneous addition of 20 ml of 25% by weight sodium hydroxide solution. After the coupling reaction had ended, 100 g of 50% strength by weight sodium hydroxide solution were metered
- 15 in. At 40-45°C 47 g of 25% strength by weight glucose solution were gradually added dropwise with stirring. After the reaction had ended (TLC check), the dye was precipitated with 130 g of concentrated hydrochloric acid and isolated by filtration. The dye thus obtained dyes paper in a blue shade ( $\lambda_{\text{max}} = 592 \text{ nm}$ ).

20

Example 35

- 16.8 g of 2-methoxy-4-nitroaniline were precharged in 200 g of water and mixed with 30 g of concentrated hydrochloric acid.
- 25 32 ml of 23% strength by weight sodium nitrite solution were then added at 0-10°C over 30 minutes. After 2 h excess nitrite was destroyed with amidosulfonic acid and the diazo component thus prepared was added at 15-20°C over 20 minutes to the coupling component prepared in Example 1. The pH was maintained at 8-9 by
- 30 the simultaneous addition of 20 ml of 25% by weight sodium hydroxide solution. After the coupling reaction had ended, 20 g of 50% strength by weight sodium hydroxide solution were metered in. At 90°C 135 g of 10% strength by weight glucose solution were gradually added dropwise with stirring. After the reaction had
- 35 ended (TLC check), the dye was precipitated with 80 g of concentrated hydrochloric acid and isolated by filtration.

Example 36

- 40 16.8 g of 2-methoxy-4-nitroaniline were precharged in 200 g of water and mixed with 30 g of concentrated hydrochloric acid. 32 ml of 23% strength by weight sodium nitrite solution were then added at 0-10°C over 30 minutes. After 2 h excess nitrite was destroyed with amidosulfonic acid and the diazo component thus
- 45 prepared was added at 15-20°C over 20 minutes to the coupling component prepared in Example 1. The pH was maintained at 8-9 by the simultaneous addition of 20 ml of 25% by weight sodium

hydroxide solution. After the coupling reaction had ended, 100 g of 50% strength by weight sodium hydroxide solution were metered in. At 60°C 44 g of 25% strength by weight glucose solution were gradually added dropwise with stirring. After the reaction had ended (TLC check), the dye was precipitated with 130 g of concentrated hydrochloric acid and isolated by filtration.

## Example 37

- 10 18.2 g of 5-nitroanthranilic acid were precharged in 290 g of water and mixed with 40 g of concentrated hydrochloric acid. 32 ml of 23% strength by weight sodium nitrite solution were then added at 0-10°C over 30 minutes. After 2 h excess nitrite was destroyed with amidosulfonic acid and the diazo component thus prepared was added at 15-20°C over 20 minutes to the coupling component prepared in Example 1. The pH was maintained at 8-9 by the simultaneous addition of 200 ml of 10% by weight sodium hydroxide solution. After the coupling reaction had ended, 40 g of 50% strength by weight sodium hydroxide solution were metered into the suspension. At 50°C 45 ml of 10% strength by weight glucose solution were gradually added dropwise with stirring. After the reaction had ended (TLC check), the dye was precipitated with concentrated hydrochloric acid and isolated by filtration. The dye thus obtained dyes paper in blue shades (λ<sub>max</sub> = 556 nm).

## Example 38

- 16.8 g of 2-methoxy-4-nitroaniline were precharged in 200 g of water and mixed with 30 g of concentrated hydrochloric acid. 32 ml of 23% strength by weight sodium nitrite solution were then added at 0-10°C over 30 minutes. After 2 h excess nitrite was destroyed with amidosulfonic acid and the diazo component was adjusted with sodium acetate to pH 3-4. The coupling component prepared in Example 2 was then added at 15-20°C over 20 minutes while the pH was adjusted to 4-5 with 10% strength by weight sodium hydroxide solution. The monoazo dye was isolated by filtration. The moist presscake was introduced into 1000 g of water and admixed with 100 g of 50% strength by weight sodium hydroxide solution. At 60°C 45 ml of 25% strength by weight glucose solution were gradually added dropwise with stirring. After the reaction had ended (TLC check), the dye was precipitated with 150 g of concentrated hydrochloric acid and isolated by filtration. The dye thus obtained dyes paper in reddish blue shades (λ<sub>max</sub> = 544 nm).



## Example 39

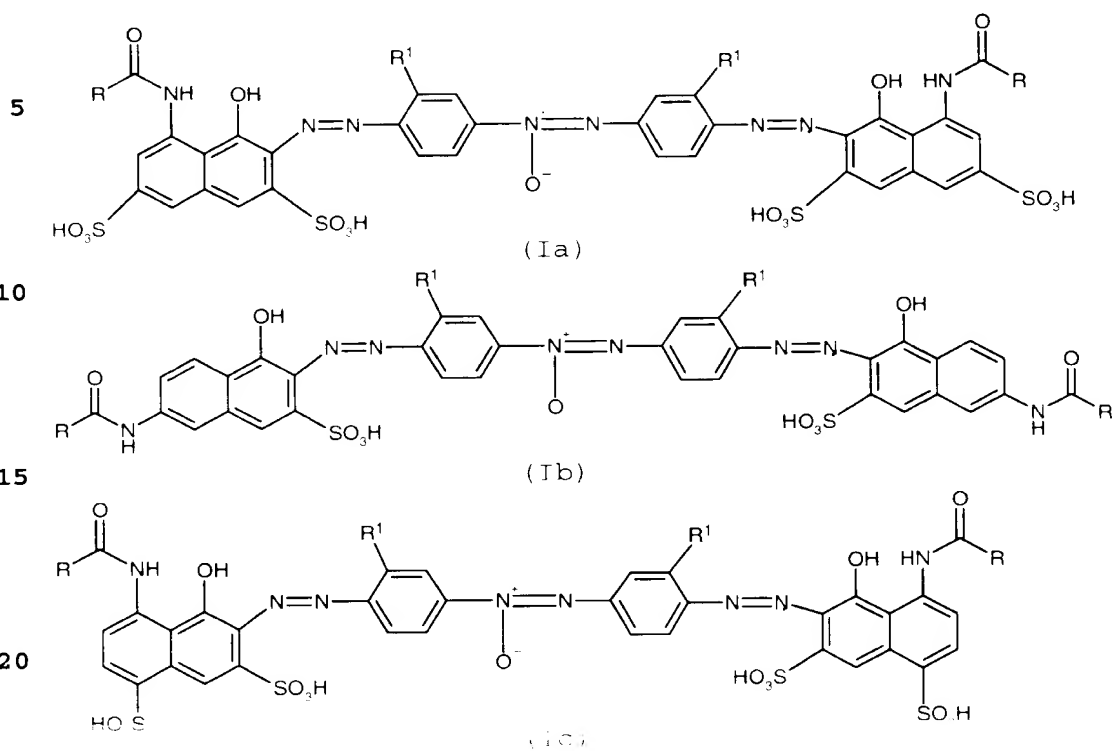
- 16.8 g of 2-methoxy-4-nitroaniline were precharged in 200 g of water and mixed with 30 g of concentrated hydrochloric acid.
- 5 32 ml of 23% strength by weight sodium nitrite solution were then added at 0-10°C over 30 minutes. After 2 h excess nitrite was destroyed with amidosulfonic acid and the diazo component thus prepared was added at 15-20°C over 20 minutes to the coupling component prepared in Example 3. The pH was maintained at 8-9 by
- 10 the simultaneous addition of 10% by weight sodium hydroxide solution. After the coupling reaction had ended, 15 g of 50% strength by weight sodium hydroxide solution were metered in. At 65°C 115 ml of 15% strength by weight glucose solution were gradually added dropwise with stirring. After the reaction had
- 15 ended (TLC check), the dye was precipitated with concentrated hydrochloric acid and isolated by filtration. The dye thus obtained dyes paper in blue shades ( $\lambda_{\max} = 590 \text{ nm}$ ).

## Example 40

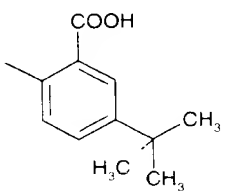
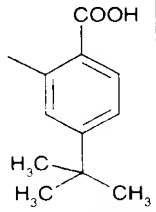
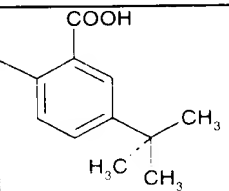
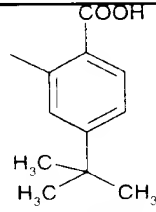
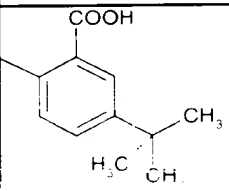
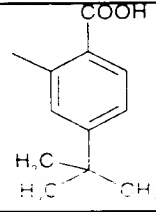
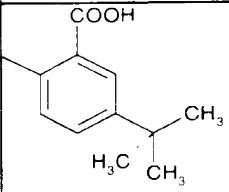
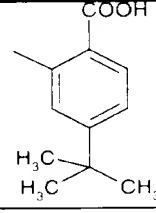
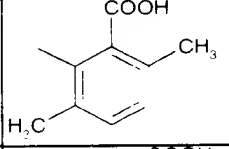
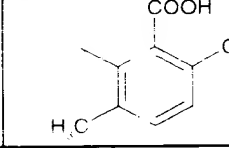
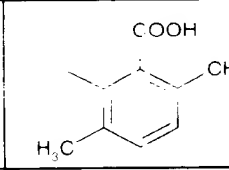
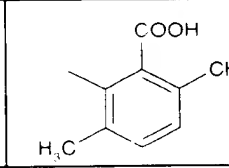
- 20 16.8 g of 2-methoxy-4-nitroaniline were precharged in 200 g of water and mixed with 30 g of concentrated hydrochloric acid. 32 ml of 23% strength by weight sodium nitrite solution were then added at 0-10°C over 30 minutes. After 2 h excess nitrite was
- 25 destroyed with amidosulfonic acid and the diazo component thus prepared was added at 15-20°C over 20 minutes to the coupling component prepared in Example 5. The pH was maintained at 8-9 by the simultaneous addition of 20 ml of 25% by weight sodium hydroxide solution. After the coupling reaction had ended, 25 g
- 30 of 50% strength by weight sodium hydroxide solution were metered in. At 60°C 130 g of 10% strength by weight glucose solution were gradually added dropwise with stirring. After the reaction had ended (TLC check), the dye was precipitated with 130 g of concentrated hydrochloric acid and isolated by filtration. The
- 35 dye thus obtained dyes paper in a blue shade ( $\lambda_{\max} = 584 \text{ nm}$ ).

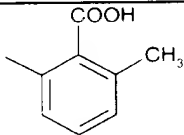
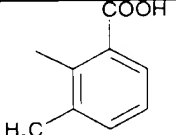
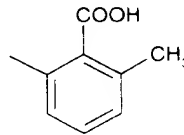
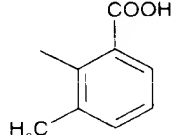
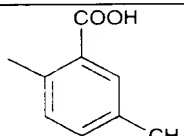
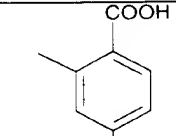
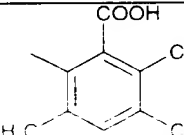
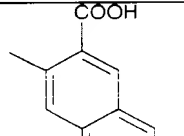
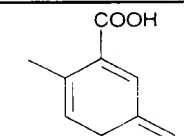
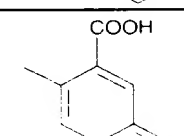
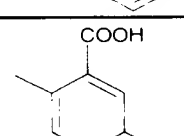
- Examples 34 - 40 were repeated to prepare the dyes of the general formulae Ia, Ib and Ic mentioned in Table 2. The choice of the best reduction conditions is adjusted to the nature of the
- 40 nitroazo compound to be used and is easy to determine in preliminary experiments. The dyes thus obtained can be isolated by adding hydrochloric acid or dyed up on paper from the reaction suspension.

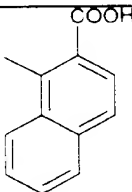
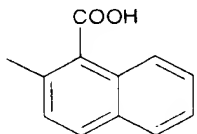
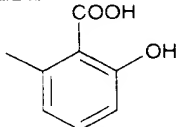
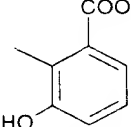
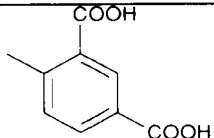
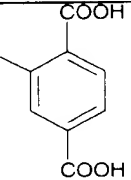
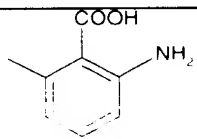
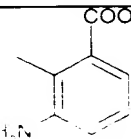
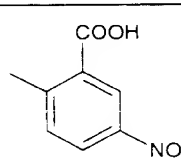
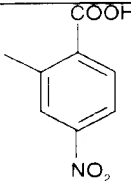
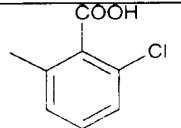
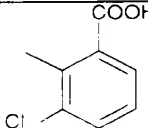
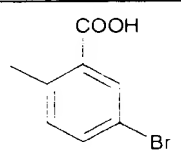
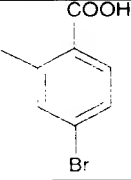
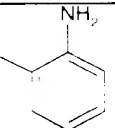
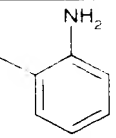
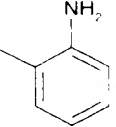
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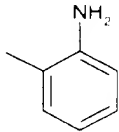
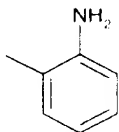
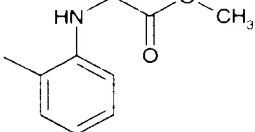
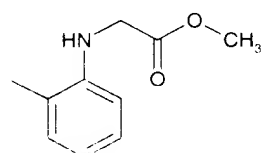
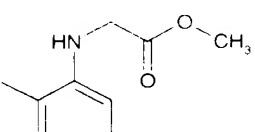
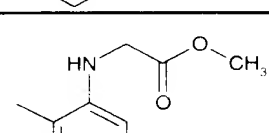
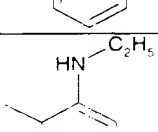
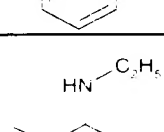
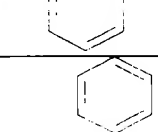


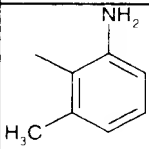
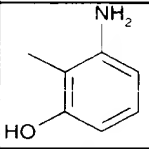
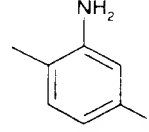
Ex.	Diazo component	Coupling component from	Formula	R <sup>1</sup>	-R
41	5-nitro-anthra-nilic acid	Ex. 5	Ib	COOH	
42	2-methoxy-4-nitro-aniline	Ex. 6	Ic	OCH <sub>3</sub>	
43	5-nitro-anthra-nilic acid	Ex. 6	Ic	COOH	
44	5-nitro-anthra-nilic acid	Ex. 3	Ia	COOH	+

Ex.	Diazo component	Coupling component from	Formula	R <sup>1</sup>	-R
5 10	45 2-methoxy-4-nitro-aniline	Ex. 7	Ib	OCH <sub>3</sub>	 
15	46 5-nitro-anthra-nilic acid	Ex. 7	Ib	COOH	 
20	47 2-methoxy-4-nitro-aniline	Ex. 8	Ic	OCH <sub>3</sub>	 
25	48 5-nitro-anthra-nilic acid	Ex. 8	Ic	COOH	 
30	49 2-methoxy-4-nitro-aniline	Ex. 9	Ia	OCH <sub>3</sub>	
35	50 5-nitro-anthra-nilic acid	Ex. 9	Ia	COOH	
40	51 2-methoxy-4-nitro-aniline	Ex. 10	Ib	OCH <sub>3</sub>	
45	52 2-methoxy-4-nitro-aniline	Ex. 11	Ic	OCH <sub>3</sub>	

Ex.	Diazo component	Coupling component from	Formula	R <sup>1</sup>	-R
53	2-methoxy-4-nitro-aniline	Ex. 12	Ia	OCH <sub>3</sub>	 + 
54	5-nitro-anthra-nilic acid	Ex. 12	Ia	COOH	 + 
55	2-methoxy-4-nitro-aniline	Ex. 13	Ia	OCH <sub>3</sub>	 + 
56	2-methoxy-4-nitro-aniline	Ex. 14	Ia	OCH <sub>3</sub>	
57	2-methoxy-4-nitro-aniline	Ex. 15	Ia	OCH <sub>3</sub>	
58	5-nitro-anthra-nilic acid	Ex. 15	Ia	COOH	
59	2-methoxy-4-nitro-aniline	Ex. 16	Ib	OCH <sub>3</sub>	
60	2-methoxy-4-nitro-aniline	Ex. 17	Ic	OCH <sub>3</sub>	

Ex.	Diazo component	Coupling component from	Formula	R <sup>1</sup>	-R
5 61	2-methoxy-4-nitro-aniline	Ex. 18	Ia	OCH <sub>3</sub>	 
10 62	2-methoxy-4-nitro-aniline	Ex. 19	Ia	OCH <sub>3</sub>	 
15 63	2-methoxy-4-nitro-aniline	Ex. 20	Ia	OCH <sub>3</sub>	 
20 64	2-methoxy-4-nitro-aniline	Ex. 21	Ia	OCH <sub>3</sub>	 
25 65	2-methoxy-4-nitro-aniline	Ex. 22	Ia	OCH <sub>3</sub>	 
30 66	2-methoxy-4-nitro-aniline	Ex. 23	Ia	OCH <sub>3</sub>	 
35 67	2-methoxy-4-nitro-aniline	Ex. 24	Ia	OCH <sub>3</sub>	 
40 68	5-nitro-anthra-nilic acid	Ex. 2	Ia	COOH	
45 69	2-methoxy-4-nitro-aniline	Ex. 25	Ib	OCH <sub>3</sub>	
70	5-nitro-anthra-nilic acid	Ex. 25	Ib	COOH	

	Ex.	Diazo component	Coupling component from	Formula	R <sup>1</sup>	-R
5	71	2-methoxy-4-nitroaniline	Ex. 26	Ic	OCH <sub>3</sub>	
10	72	5-nitroanthranilic acid	Ex. 26	Ic	COOH	
15	73	2-methoxy-4-nitroaniline	Ex. 4	Ia	OCH <sub>3</sub>	
20	74	5-nitroanthranilic acid	Ex. 4	Ia	COOH	
25	75	2-methoxy-4-nitroaniline	Ex. 27	Ib	OCH <sub>3</sub>	
30	76	2-methoxy-4-nitroaniline	Ex. 28	Ic	OCH <sub>3</sub>	
35	77	2-methoxy-4-nitroaniline	Ex. 29	Ia	OCH <sub>3</sub>	
40	78	5-nitroanthranilic acid	Ex. 29	Ia	COOH	
45	79	2-methoxy-4-nitroaniline	Ex. 30	Ia	OCH <sub>3</sub>	

Ex.	Diazo component	Coupling component from	Formula	R <sup>1</sup>	-R
5 80	2-methoxy-4-nitro-aniline	Ex. 31	Ia	OCH <sub>3</sub>	
10 81	2-methoxy-4-nitro-aniline	Ex. 32	Ia	OCH <sub>3</sub>	
15 82	2-methoxy-4-nitro-aniline	Ex. 33	Ia	OCH <sub>3</sub>	

Synthesis of copper complexes according to invention

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Copper complexes are prepared according to methods known in principle:

The dealkylating coppering of o-hydroxy-o'-methoxy-azo dyes generally takes 6-12 hours of heating at 80-90°C in an ammoniacal medium. Ammonia may be wholly or partly replaced with organic nitrogenous bases. Coppering can be performed starting from the isolated dyes or be carried out immediately following the reduction, in which case the copperless dyes are not isolated in between. If the copperless dye was isolated, both the moist presscake and the dried dye can be used. The ratio of copperless dye to singly coppered dye to doubly coppered dye depends on the amount of copper salt provided. The dyes thus prepared are partly precipitated with hydrochloric acid and partly dyed up on paper directly from the reaction solution. The dyes can be obtained as stable liquid formulations in the form of their salts (e.g., lithium, sodium, potassium; (optionally substituted) ammonium) by means of customary methods.

40 Example 83

1/5 of the isolated dye prepared according to Example 34 was slurried up in 250 g of water and admixed with 5.5 g of diethanolamine and 0.75 g of copper(II) sulfate pentahydrate. The pH was then adjusted to 8.5-9 using 10% strength by weight sodium hydroxide solution. The reaction mixture was then stirred at that

pH and 90°C for 7 h. The dye thus obtained dyes paper in a blue shade ( $\lambda_{\text{max}}$  = 598 nm).

Example 84

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1/5 of the isolated dye prepared according to Example 34 was slurried up in 250 g of water and admixed with 5.5 g of diethanolamine and 1.25 g of copper(II) sulfate pentahydrate. The pH was then adjusted to 8.5-9 using 10% strength by weight sodium hydroxide solution. The reaction mixture was then stirred at that pH and 90°C for 7 h. The dye thus obtained dyes paper in a blue shade ( $\lambda_{\text{max}}$  = 600 nm).

Example 85

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1/5 of the isolated dye prepared according to Example 34 was slurried up in 250 g of water and admixed with 5.5 g of diethanolamine and 1.75 g of copper(II) sulfate pentahydrate. The pH was then adjusted to 8.5-9 using 10% strength by weight sodium hydroxide solution. The reaction mixture was then stirred at that pH and 90°C for 7 h. The dye thus obtained dyes paper in a blue shade ( $\lambda_{\text{max}}$  = 602 nm).

Example 86

25

1/5 of the isolated dye prepared according to Example 34 was slurried up in 250 g of water and admixed with 5.5 g of diethanolamine and 2.25 g of copper(II) sulfate pentahydrate. The pH was then adjusted to 8.5-9 using 10% strength by weight sodium hydroxide solution. The reaction mixture was then stirred at that pH and 90°C for 7 h. The dye thus obtained dyes paper in a blue shade ( $\lambda_{\text{max}}$  = 606 nm).

Example 87

35

1/5 of the isolated dye prepared according to Example 34 was slurried up in 250 g of water and admixed with 5.5 g of diethanolamine and 2.75 g of copper(II) sulfate pentahydrate. The pH was then adjusted to 8.5-9 using 10% strength by weight sodium hydroxide solution. The reaction mixture was then stirred at that pH and 90°C for 7 h. The dye thus obtained dyes paper in a blue shade ( $\lambda_{\text{max}}$  = 610 nm).

45



## Example 88

- 1/5 of the isolated dye prepared according to Example 34 was slurried up in 250 g of water and admixed with 5.5 g of
- 15 diethanolamine and 3.25 g of copper(II) sulfate pentahydrate. The pH was then adjusted to 8.5-9 using 10% strength by weight sodium hydroxide solution. The reaction mixture was then stirred at that pH and 90°C for 7 h. The dye thus obtained dyes paper in a blue shade ( $\lambda_{\max} = 614 \text{ nm}$ ).

10

## Example 89

- 1/5 of the isolated dye prepared according to Example 34 was slurried up in 250 g of water and admixed with 5.5 g of
- 15 diethanolamine and 3.75 g of copper(II) sulfate pentahydrate. The pH was then adjusted to 8.5-9 using 10% strength by weight sodium hydroxide solution. The reaction mixture was then stirred at that pH and 90°C for 7 h. The dye thus obtained dyes paper in a blue shade ( $\lambda_{\max} = 618 \text{ nm}$ ).

20

## Example 90

- 1/5 of the isolated dye prepared according to Example 34 was slurried up in 250 g of water and admixed with 5.5 g of
- 25 diethanolamine and 4.25 g of copper(II) sulfate pentahydrate. The pH was then adjusted to 8.5-9 using 10% strength by weight sodium hydroxide solution. The reaction mixture was then stirred at that pH and 90°C for 7 h. The dye thus obtained dyes paper in a blue shade ( $\lambda_{\max} = 618 \text{ nm}$ ).

30

## Example 91

- 1/5 of the isolated dye prepared according to Example 34 was slurried up in 250 g of water and admixed with 5.5 g of
- 35 diethanolamine and 4.5 g of copper(II) sulfate pentahydrate. The pH was then adjusted to 8.5-9 using 10% strength by weight sodium hydroxide solution. The reaction mixture was then stirred at that pH and 90°C for 7 h. The dye thus obtained dyes paper in a blue shade ( $\lambda_{\max} = 621 \text{ nm}$ ).

40

## Example 92

- 1/5 of the isolated dye prepared according to Example 34 was slurried up in 250 g of water and admixed with 5.5 g of
- 45 diethanolamine and 5 g of copper(II) sulfate pentahydrate. The pH was then adjusted to 8.5-9 using 10% strength by weight sodium hydroxide solution. The reaction mixture was then stirred at that

pH and 90°C for 7 h. The dye thus obtained dyes paper in a blue shade ( $\lambda_{\text{max}}$  = 626 nm).

Example 93

5

The dyes prepared in Examples 34, 83, 84, 85, 86, 87, 88, 89, 90, 91 and 92 are pulp-dyed up in a conventional manner onto various papery material models to 1/6 standard depth of shade. It is found that the hue of the dyes becomes greener in the stated  
10 order and that the lightfastness increases.

Example 94

1/5 of the reaction suspension of the dye prepared according to  
15 Example 34 was diluted with 170 g of water and admixed with 5.5 g of diethanolamine and 2.75 g of copper(II) sulfate pentahydrate. The pH was then adjusted to 8.5-9 using 10% strength by weight sodium hydroxide solution. The reaction mixture was then stirred at that pH and 90°C for 7 h. The dye thus obtained dyes paper in a  
20 blue shade ( $\lambda_{\text{max}}$  = 602 nm).

Example 95

1/5 of the reaction suspension of the dye prepared according to  
25 Example 34 was diluted with 170 g of water and admixed with 5.5 g of diethanolamine and 5.2 g of copper(II) sulfate pentahydrate. The pH was then adjusted to 8.5-9 using 10% strength by weight sodium hydroxide solution. The reaction mixture was then stirred at that pH and 90°C for 7 h. The dye thus obtained dyes paper in a  
30 blue shade ( $\lambda_{\text{max}}$  = 608 nm).

Example 96

3/5 of the isolated dye prepared according to Example 34 was  
35 slurried up in 750 g of water and admixed with 16.5 g of diethanolamine and 7.8 g of copper acetate. The pH was then adjusted to 8.5-9 using 10% strength by weight sodium hydroxide solution. The reaction mixture was then stirred at that pH and 80°C for 8 h. The dye thus obtained dyes paper in a blue shade  
40 ( $\lambda_{\text{max}}$  = 614 nm).

Example 97

1/5 of the isolated dye prepared according to Example 34 was  
45 slurried up in 155 g of water and admixed with 5.5 g of diethanolamine and 2.6 g of copper acetate. The pH was then adjusted to 8.5-9 using 10% strength by weight sodium hydroxide

solution. The reaction mixture was then stirred at that pH and 80°C for 8 h. The dye thus obtained dyes paper in a blue shade ( $\lambda_{\max} = 612 \text{ nm}$ ).

#### 5 Example 98

1/5 of the reaction suspension of the dye prepared according to Example 39 was diluted with 140 g of water and admixed with 5.5 g of diethanolamine and 6 g of copper(II) sulfate pentahydrate. The reaction mixture was then stirred at 85°C for 6 h. The dye thus obtained dyes paper in a blue shade ( $\lambda_{\max} = 620 \text{ nm}$ ).

#### Example 99

15 1/5 of the reaction suspension of the dye prepared according to Example 39 was diluted with 140 g of water and admixed with 18 g of 25% strength ammonia and 6 g of copper(II) sulfate pentahydrate. The reaction mixture was then stirred at 85°C for 6 h. The dye thus obtained dyes paper in a blue shade ( $\lambda_{\max} = 604 \text{ nm}$ ).

#### Example 100

25 1/5 of the reaction suspension of the dye prepared according to Example 40 was diluted with 140 g of water and admixed with 5.5 g of diethanolamine and 6 g of copper(II) sulfate pentahydrate. The reaction mixture was then stirred at 85°C for 6 h. The dye thus obtained dyes paper in a blue shade ( $\lambda_{\max} = 588 \text{ nm}$ ).

#### 30 Example 101

1/5 of the reaction suspension of the dye prepared according to Example 40 was diluted with 140 g of water and admixed with 18 g of 25% strength ammonia and 6 g of copper(II) sulfate pentahydrate. The reaction mixture was then stirred at 85°C for 6 h. The dye thus obtained dyes paper in a blue shade ( $\lambda_{\max} = 586 \text{ nm}$ ).

#### Example 102

#### 40

2.5 of the isolated dye prepared according to Example 38 was slurried up in 365 g of water and admixed with 11 g of diethanolamine and 10 g of copper(II) sulfate pentahydrate. The reaction mixture was then stirred at 85°C for 6 h. The dye thus obtained dyes paper in a blue shade.

Half the batch was bottled as reaction suspension. ( $\lambda_{\max} = 564 \text{ nm}$ ).

The other half of the batch was admixed with 25 g of concentrated hydrochloric acid and the precipitated dye was filtered off, washed with sodium chloride solution and then dried under reduced pressure at 50-60°C. ( $\lambda_{\max}$  = 546 nm).

5

### Example 103

2/5 of the isolated dye prepared according to Example 38 was slurried up in 365 g of water and admixed with 36 g of 25% strength ammonia and 10 g of copper(II) sulfate pentahydrate. The reaction mixture was then stirred at 85°C for 6 h. The dye thus obtained dyes paper in a blue shade.

Half the batch was bottled as reaction suspension. ( $\lambda_{\max}$  = 564 nm).

15 The other half of the batch was admixed with 25 g of concentrated hydrochloric acid and the precipitated dye was filtered off, washed with sodium chloride solution and then dried under reduced pressure at 50-60°C. ( $\lambda_{\max}$  = 546 nm).

20 Examples 83 - 103 were repeated to convert the azoxy dyes of Examples 41-82, depending on the conditions recited in Table 3, into dye mixtures comprising the uncomplexed singly copper-complexed and doubly copper-complexed azoxy dye, which dye paper uniformly and have good fastnesses. The choice of the best reaction conditions (pH, temperature, reaction time) is adjusted to the nature of the dye to be used and is easily determined in preliminary experiments. The dyes thus obtained can be isolated by adding an acid or be dyed up on paper from the reaction suspension.

30

Table 3:

Example	Azoxy dye	Moles of Cu salt per mole of dye
104	Example 42	1
105	Example 42	2
106	Example 45	1
107	Example 45	1.5
108	Example 45	2
109	Example 47	2
110	Example 49	2
111	Example 51	2
112	Example 52	2
113	Example 53	2
114	Example 55	2
115	Example 56	2
116	Example 57	2
117	Example 59	2
118	Example 61	2
119	Example 62	2

Example	Azoxy dye	Moles of Cu salt per mole of dye
120	Example 66	2
121	Example 69	1
122	Example 69	2
123	Example 71	2
124	Example 73	1
125	Example 73	2
126	Example 75	2
127	Example 77	2
128	Example 80	2

The copper complexes of water-soluble o-hydroxy-o'-carboxy-azo dyes are formed under mild conditions at room temperature in the weakly acidic or ammoniacal pH range. On an industrial scale, elevated temperatures are used for solubility reasons. When the metallization is carried out in the acidic range, the liberated mineral acid is buffered off with sodium acetate. With this class of compounds too the coppering can be conducted starting from the isolated dyes or be carried out directly following the reduction, in which case the copperless dyes are not intermediately isolated. If the copperless dye was isolated, both the moist presscake and the dried dye can be used. The ratio of copperless dye to singly coppered dye to doubly coppered dye depends on the amount of copper salt provided. The dyes thus prepared are partly precipitated with hydrochloric acid and partly dyed up on paper directly from the reaction solution. The dyes can be obtained as stable liquid formulations in the form of their salts (e.g., lithium, sodium, potassium; (optionally substituted) ammonium) by means of customary methods.

#### Example 129

1/5 of the isolated dye prepared according to Example 37 was slurried up in 150 g of water and admixed with 10 g of diethanolamine and 5 g of copper(II) sulfate pentahydrate. The pH was then adjusted to 10 using 10% strength by weight sodium hydroxide solution. The reaction mixture was then stirred at 90°C for 8 h. The dye thus obtained dyes paper in a blue shade ( $\lambda_{\text{max}} = 574 \text{ nm}$ ).

#### Example 130

1/5 of the isolated dye prepared according to Example 37 was slurried up in 150 g of water and admixed with 4.5 g of 25% strength ammonia and 5 g of copper(II) sulfate pentahydrate. The pH was then adjusted to 9.5 using 10% strength by weight sodium hydroxide solution. The reaction mixture was then stirred at 90°C

for 8 h. The dye thus obtained dyes paper in a blue shade ( $\lambda_{\max} = 576 \text{ nm}$ ).

Example 131

- 5 1/5 of the isolated dye prepared according to Example 37 was slurried up in 150 g of water and admixed with 5 g of copper(II) sulfate pentahydrate. The pH was then adjusted to 4 using 10% strength by weight sodium hydroxide solution. The reaction
- 10 mixture was then stirred at 90°C for 8 h. The dye thus obtained dyes paper in a blue shade ( $\lambda_{\max} = 602 \text{ nm}$ ).

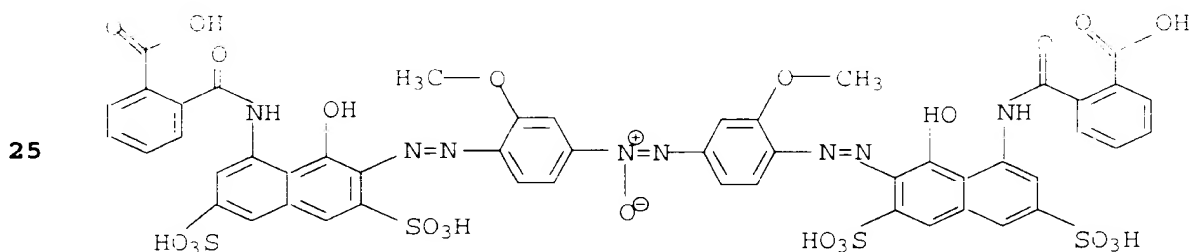
- Examples 129 - 131 were repeated to convert the azoxy dyes of Examples 41-82, depending on the conditions recited in Table 4,
- 15 into dye mixtures comprising the uncomplexed, singly copper-complexed and doubly copper-complexed azoxy dye, which dye paper uniformly and have good fastnesses. The choice of the best reaction conditions (pH, temperature, reaction time) is adjusted to the nature of the dye to be used and is easily determined in
- 20 preliminary experiments. The dyes thus obtained can be isolated by adding an acid or be dyed up on paper from the reaction suspension.

Table 4:

25	Example	Azoxy dye	Moles of Cu salt per mole of dye
	132	Example 37	1
	133	Example 41	1
	134	Example 41	2
30	135	Example 43	1
	136	Example 43	2
	137	Example 44	2
	138	Example 46	2
	139	Example 48	2
	140	Example 50	2
35	141	Example 54	2
	142	Example 58	2
	143	Example 68	1
	144	Example 68	1.5
	145	Example 68	2
40	146	Example 70	2
	147	Example 72	2
	148	Example 74	2
	149	Example 78	2

## Example 150

- 16.8 g of 2-methoxy-4-nitroaniline were precharged in 200 g of water and admixed with 30 g of concentrated hydrochloric acid.
- 5 32 ml of 23% strength by weight sodium nitrite solution were then added at 0-10°C over 30 minutes. After 2 h excess nitrite was destroyed with amidosulfonic acid and the diazo component thus prepared was added at 15-20°C over 20 minutes to the coupling component prepared in Example 1. The pH was maintained at 8-9 by
- 10 the simultaneous addition of 20 ml of 25% strength by weight sodium hydroxide solution. After the coupling reaction had ended, 75 g of 50% strength by weight sodium hydroxide solution were metered in. At 40-45°C 47.5 g of 25% strength by weight glucose solution were gradually added dropwise with stirring. After the
- 15 reaction had ended (TLC check), the dye was adjusted with 79 g of concentrated hydrochloric acid and stirred at 60°C for 6 h. 19 g of concentrated hydrochloric acid were then added to adjust the pH to 2.2 and, after cooling of the suspension, the dye was isolated by filtration. The dye thus obtained of the formula
- 20



- 30 dyes paper in a blue shade ( $\lambda_{\max} = 596 \text{ nm}$ ).

## Example 151

- 1/5 of the isolated dye prepared according to Example 150 was
- 35 slurried up in 155 g of water and admixed with 5.5 g of diethanolamine and 2.25 g of copper(II) sulfate pentahydrate. The pH was then adjusted to 8.5-9 using 10% strength by weight sodium hydroxide solution. The reaction mixture was then stirred at that pH and 90°C for 7 h. The dye thus obtained dyes paper in a blue
- 40 shade ( $\lambda_{\max} = 606 \text{ nm}$ ).

## Example 152

- 1/5 of the isolated dye prepared according to Example 150 was
- 45 slurried up in 155 g of water and admixed with 5.5 g of diethanolamine and 3.25 g of copper(II) sulfate pentahydrate. The pH was then adjusted to 8.5-9 using 10% strength by weight sodium

hydroxide solution. The reaction mixture was then stirred at that pH and 90°C for 7 h. The dye thus obtained dyes paper in a blue shade ( $\lambda_{\text{max}} = 618 \text{ nm}$ ).

#### 5 Example 153

2/5 of the isolated dye prepared according to Example 150 was slurried up in 310 g of water and admixed with 11 g of diethanolamine and 8.5 g of copper(II) sulfate pentahydrate. The pH was then adjusted to 8.5-9 using 10% strength by weight sodium hydroxide solution. The reaction mixture was then stirred at that pH and 90°C for 7 h. The dye thus obtained dyes paper in a blue shade ( $\lambda_{\text{max}} = 626 \text{ nm}$ ).

#### 15 Example 154

16.8 g of 2-methoxy-4-nitroaniline were precharged in 150 g of water and admixed with 30 g of concentrated hydrochloric acid. 32 ml of a 23% strength by weight sodium nitrite solution were then added at 0-10°C over 30 minutes. After 2 h excess nitrite was destroyed with amidosulfonic acid and the diazo component thus prepared was added at 15-20°C over 30 minutes to the coupling component prepared in Example 1. The pH was maintained at about 9 by the simultaneous addition of 20 ml of 25% strength by weight sodium hydroxide solution. After the coupling reaction had ended, 40 g of 50% strength by weight sodium hydroxide solution were metered in. At 50-55°C 12.3 g of glucose were added a little at a time. After the reaction had ended (TLC check) the pH was adjusted to 8 by addition of 33 g of concentrated hydrochloric acid and the reaction mixture was stirred at 90°C for 2 h. At that point, amide cleavage was complete. After cooling to room temperature the pH was adjusted to 8 by addition of 5 g of 50% strength by weight sodium hydroxide solution and the dye was isolated by filtration. The dye thus obtained dyes paper in a blue shade ( $\lambda_{\text{max}} = 598 \text{ nm}$ ).

#### Example 155

1/5 of the isolated dye prepared according to Example 154 was slurried up in 110 g of water and admixed with 3.7 g of ethanolamine. 2.25 g of copper(II) sulfate pentahydrate dissolved in 25 g of water were added at 50°C and the reaction mixture was stirred at 90°C and pH 8.5-9.5 for 7 h. The dye mixture thus obtained dyes paper in a blue shade ( $\lambda_{\text{max}} = 606 \text{ nm}$ ).



## Example 156

1/5 of the isolated dye prepared according to Example 154 was slurried up in 97 g of water by addition of 13 g of urea. 2.25 g of copper(II) sulfate pentahydrate dissolved in 25 g of water were added at 50°C and the reaction mixture was stirred at 90°C and pH 8.5-9.5 for 7 h. The dye mixture thus obtained dyes paper in a blue shade ( $\lambda_{\max} = 606 \text{ nm}$ ).

## 10 Example 157

1/5 of the isolated dye prepared according to Example 154 was slurried up in 110 g of water and admixed with 3.7 g of ethanolamine. 2.75 g of copper(II) sulfate pentahydrate dissolved in 25 g of water were added at 50°C and the reaction mixture was stirred at 90°C and pH 8.5-9.5 for 7 h. The dye mixture thus obtained dyes paper in a blue shade ( $\lambda_{\max} = 606 \text{ nm}$ ).

## Example 158

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1/5 of the isolated dye prepared according to Example 154 was slurried up in 97 g of water by addition of 13 g of urea and admixed with 3.7 g of ethanolamine. 2.75 g of copper(II) sulfate pentahydrate dissolved in 25 g of water were added at 50°C and the reaction mixture was stirred at 90°C and pH 8.5-9.5 for 7 h. The dye mixture thus obtained dyes paper in a blue shade ( $\lambda_{\max} = 606 \text{ nm}$ ).

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